

Work Order ID 85094

85094

Page 1

June-01-12 3:42:44 PM

Item ID: D350-578-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bearpaw

Stop *NS2*

Start Date: 01/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2672

Rev B1

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-021 CHG005

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Pick: Packing Kit
(Note: D2672B is on the BOM as material from step 3)

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

Quality Control

DAS 12/07/13

16

9-03

MLJ 12-7-10
(4)

4

12/07/10 JB

DAS 12/07/13

16

9-03

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 85094***85094***

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 01/06/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

0.00

180

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D350-578-021

Identify and Stock

Location: NVA

190

0.00

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

*Chp/13**12/7/17**MF**12-07-13*

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Picklist Print

June-01-12 3:42:48 PM

Page 1

Work Order ID: 85094

85094

Parent Item: D350-578-021

D350-578-021

Parent Item Name: Bearpaw

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-01-02 JLM

IPP Rev:B New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2672		Manufactured	No			100	Each	1.0000	8	8			
-------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2672
Bearpaw 4 1/2" X 24", 206

Location

Loc Qty

Loc Code

ST495

1

73110

1

AN4-17A

Purchased

No

160

Each

580.0000

48

AN4-17A
Bolt

Location

Loc Qty

Loc Code

ST358

300

116704

0

121541

300

ST359

280

112314

0

121011

200

121068

80

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

30.0000

96

AN960JD416
Washer

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 85094

Parent Item: D350-578-021

Parent Item Name: Bearpaw

85094

D350-578-021

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2182B

Manufactured No

160 f

128.5952 2.5 10 ✓

D2182B

Rubber Cushion

**

JB 80

Location

Loc Qty

Loc Code

ST410

128.59517

63413

1.6

66063

41.61817

73932

85.377

73932

(D2182B050) 6 X 5.00" PER KIT

D2274

Manufactured No

160 Each

623.0000

12 48 ✓

D2274

Radius Block

**

JB 80

Location

Loc Qty

Loc Code

ST007

623

78233

2

81958

160

83258

210

84199

251

84199

D2438

Manufactured No

160 Each

84.0000

6 24 ✓

D2438

Clamp

**

86871 JB 12/07/10

Location

Loc Qty

Loc Code

ST456

84

77038

6

83265

28

83266

50

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-578-021

D350-578-021

Parent Item Name: Bearpaw

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2529

Manufactured No

160

Each

761.0000

12

48

**

✓

JB

JB

D2529

Washer

Location

Loc Qty

Loc Code

ST010

761

79485

18

81873

243

84435

500

84435

MS21042L4

Purchased

No

160

Each

3,910.000

12

48

**

✓

JB

12/07/10

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

121444

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

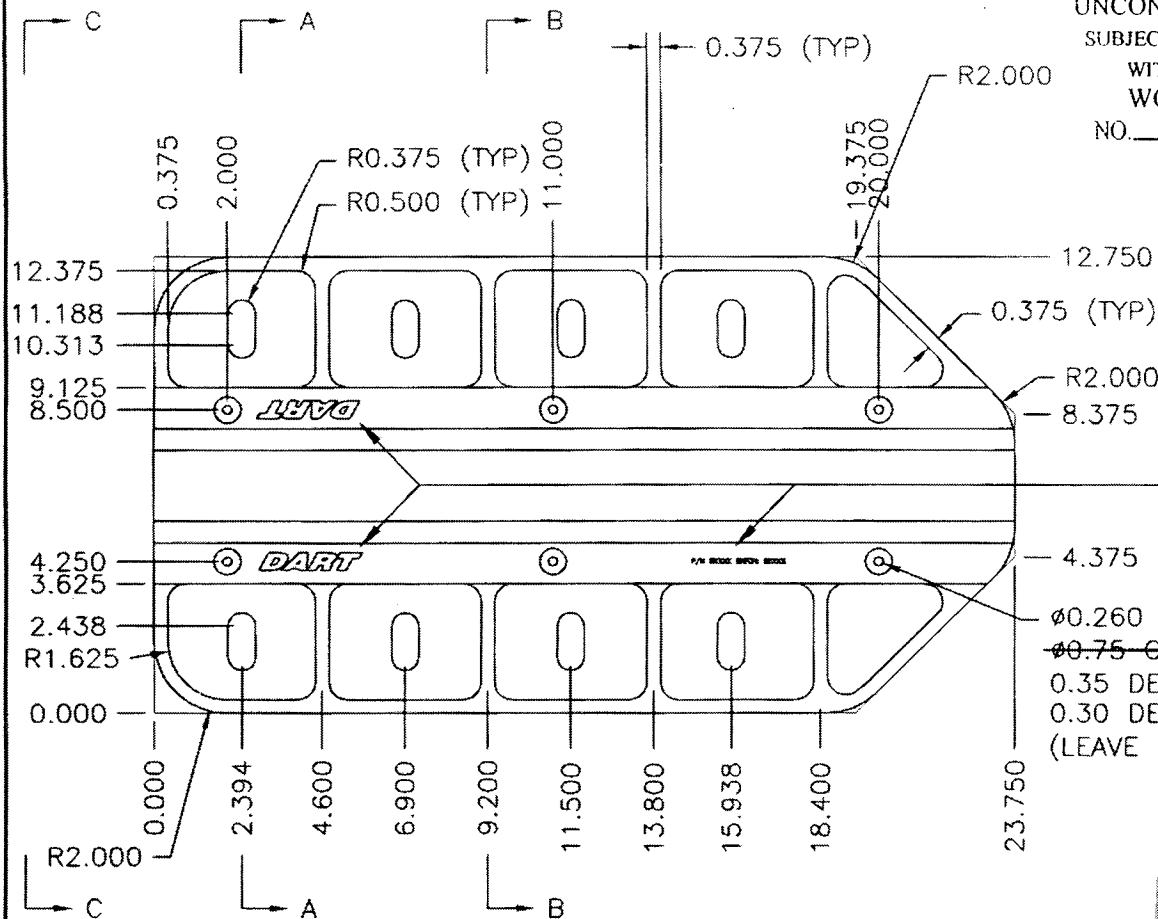
WORK ORDER

NO. 85094 MJS 12/06/04

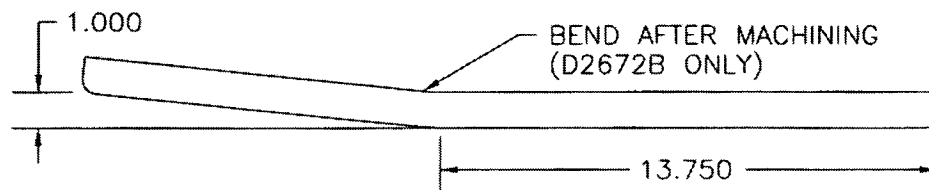
ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)

DART

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FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

EFFECTIVE DECS

RELEASED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>KE</i>	APPROVED <i>KE</i>	HAWKESBURY, ONTARIO, CANADA
DATE 98.05.19	TITLE BEARPAW	REV. B
A	97.04.08	NEW ISSUE
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50
B1	02.10.22	0.43 WAS 0.75
SCALE 1:5		SHEET 1 OF 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

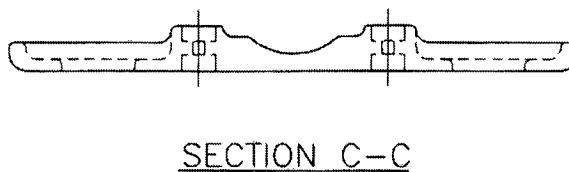
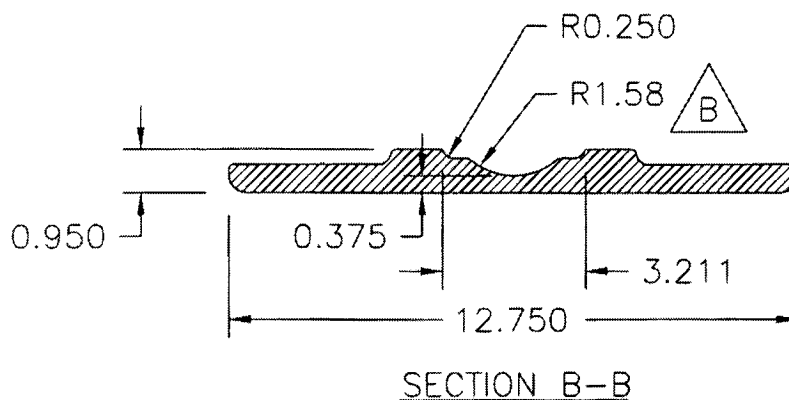
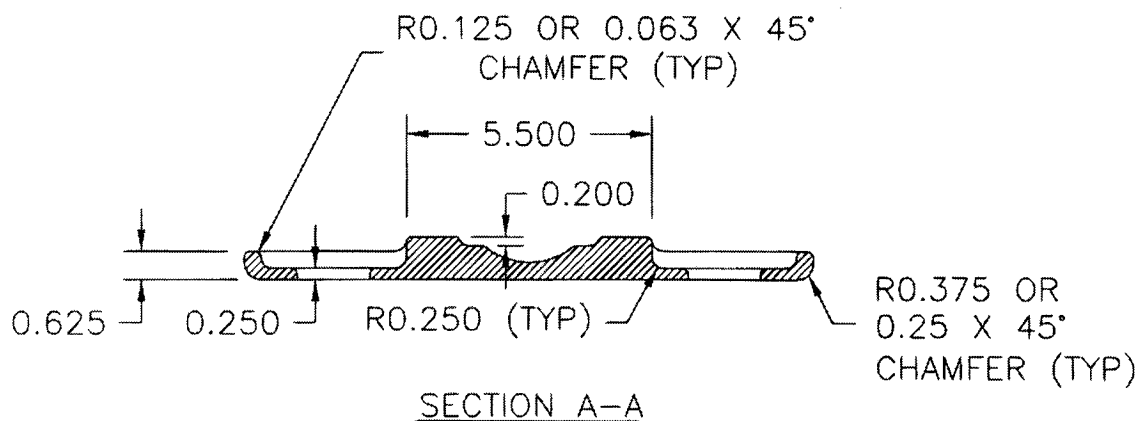
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>SA</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



85094

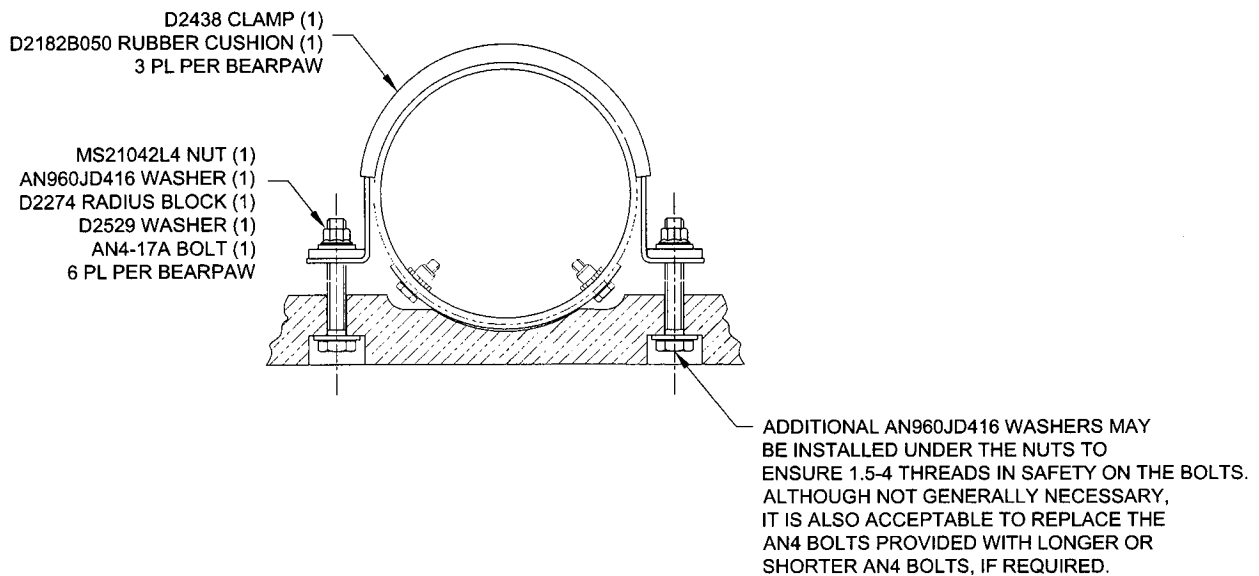
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Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)